

Date: Thursday, 3/13/2008 10:19:23 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HI-STEP LEG ASSEMBLY
Job Number : 37925	
Estimate Number : 10355	
P.O. Number :	Part Number : D2582
This Issue : 3/13/2008 S.O. No. :	Drawing Number : D2582 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 37452	Material :
Written By :	Due Date : 3/28/2008 Qty: 14 Um: Each
Checked & Approved By : <u>H 08 03 13</u>	
Comment :	
Est Rev:F Removed Manufacturing 05-11-07 JLM	
Est Rev:G Added part # to Sub 06-08-10 JLM	
Est Rev H New pick list 08.01.11 EC	
verified by: DD	

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	37925A	STEP LEG
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Comment: Sub-Component STEP LEG
D2278 B 37925A (1)

B 37452A (7)

2.0	37925B	STEP SPACER
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Comment: Sub-Component STEP SPACER
D2322 B B 36710B (7)

B 37452B (2) B 37925A (5)

3.0	37925C	STEP SPACER
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Comment: Sub-Component STEP SPACER
D2279 B B 22585 (1)

B 31407D (3)

4.0	37925D	STEP SPACER
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Comment: Sub-Component STEP SPACER
D3720-1

B 37925D x11 ✓

B 37452D x2 ✓

B 36710 D x1 ✓

ml 08/04/02

5.0	37925E	STEP SPACER
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Comment: Sub-Component STEP SPACER
D3720-2

B 37925E x9 ✓

B 36710 x2 ✓

B 37452 E x3

ml

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/13/2008 10:19:23 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 37925

Part Number: D2582

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 22.0000 Each(s)/Unit Total : ~~220.0000~~ Each(s) 308

Pick:

Qty Part Number Description Batch

22 MS20470AD4-4 Rivet

M106550 ?

ml

7.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 4.0000 Each(s)/Unit Total : ~~40.0000~~ Each(s) 56

Pick:

Qty Part Number Description Batch

4 MS20470AD4-5 Rivet

M104156

✓ ml

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D2582 and

ml 08/04/02 x14

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/03 (x14)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

08 04 07

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/09

Job Completion



mf 08-04-08

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2278 STEP LEG
(2 PLACES)

MS20470AD4-4 RIVET
(5 PLACES PER SIDE)
(INSTALL FROM OUTSIDE OF ASSEMBLY)

D2278 STEP SPACER

D2322 STEP SPACER

MS20470AD4-4 RIVET
(6 PLACES PER SIDE)
(INSTALL FROM OUTSIDE OF ASSEMBLY)

D2582 STEP LEG ASSEMBLY

MS20470AD4-5 RIVET
(2 PLACES)

MS20470AD4-5 RIVET
(2 PLACES)

B
D3720-2 STEP SPACER

B
D3720-1 STEP SPACER

C'SINK ON INSIDE
GRIND RIVET FLUSH TO
SURFACE AS REQUIRED
(BOTH SIDES)

NO 37925
WORK IN PROGRESS
UNCONTROLLED COPY
SUBJECT TO AN ENGINEERING
WITHOUT NOTICE
RETURN TO
ENGINEERING
SHOP COPY

D2582 STEP LEG ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D2582	STEP LEG ASSEMBLY
2	D2278	STEP LEG
1	D2279	STEP SPACER
1	D2322	STEP SPACER
1	D3720-1	STEP SPACER
1	D3720-2	STEP SPACER
22	MS20470AD4-4	RIVET
4	MS20470AD4-5	RIVET

NOTES:

- 1) FINISH: NONE
- 2) IDENTIFICATION: IDENTIFY WITH DART P/N "D2582" USING FINE POINT PERMANENT INK MARKER WHERE INDICATED
- 3) WEIGHT: 1.25 lbs.

B	REPLACE D2280 SPACERS WITH D3720-1/2 SPACERS REFERENCE NCR 263 UPDATE DRAWING FORMAT	PH	07.12.27
A	NEW ISSUE	CP	01.10.05
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH	DRAWING NO. D2582	
CHECKED	LS	REV. B SHEET 1 OF 1	
MFG. APPR.	LS	TITLE STEP LEG ASSEMBLY	
APPROVED	LS	SCALE NTS	
DE APPR.	LS	DATE 07.12.27	
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RELEASED
06-01-10